

Date: Friday, 13/03/2009 4:50:08 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT X-TUBE EXT HEIGHT GEAR
<b>Job Number</b> : 46483	
<b>Estimate Number</b> : 10421	
<b>P.O. Number</b> :	<b>Part Number</b> : D205596103 <i>107B</i>
<b>This Issue</b> : 13/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D205-596-103 <i>W</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 46482	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>JUD 09.03.13</i>	
<b>Comment</b> : Est Rev:G 05.06.10 Acid etch moved to Step 11 KJ/JLM Est Rev:H 08-01-10 ECN 1075 DD Est Rev F 08.04.28 Added bending & mat'l EC verified by: DD	



## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROLPhotocopy D205-594 bluefile & type labels per PPP D205-596-103 *107* CHG002 CHG 001 *S0260402*

2.0	D6008180	Crosstube Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Extrusion

Batch: *B-402713**MB 09-03-25**①*

3.0	BENDING CROSS	BENDING MACHINE - CROSSTUBES
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**Comment:** BENDING MACHINE - CROSSTUBES

Bend as per dwg D2890 using CNC bender program

*MB**09-03-26**①*

4.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1


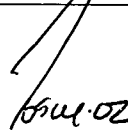
1-Mark 37.30" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

*MB**09-03-26**①*

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES*090331 -> now 14-107**MB**09/03/07*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.03.31	1	IDENTIFY TUBE: DZ05-596-147B CHG 001 INCLUDE DSI 9455 REL.A. RED LABEL: 214 A/L ONLY	CP HJ	09.04.02 09/04/02		CP 09.03.31 pc DSI 042		
09.03.31	15	INSTALL XTUBE SUPPORTS 13.75" FROM XTUBE E. ABOUT	II	09.04.02		CP 09.03.31 pc DSI 042		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/03/2009 4:50:09 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 46483

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103

25 09-03-27 / MB 09-03-31 ①

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube. AWM 9-3-30 ①

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

25 09-03-31 ①

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

TOUCH UP Chemical Conversion Coat as per QSI 005 4.1

AWM 9-3-30 ①

MB 09-03-31 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

25 09-03-31 ①

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

25 09-03-31

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

25 09-03-31

12.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION

batch 40780

25 09-04-01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	
09-03-31	10.0	Prime inside of tube as per QSP <del>2</del> 005 4.2 Prime outside of tube as per QSP 005 4.1 Start time <u>10:30</u> Finish time <u>11:30</u>	ET	09-03-31				
		paint outside of tube with Intron as per QSP Start time <u>3:00</u> 005 4.2 Finish time <u>4:00</u> <i>Perm Change</i>	ET	09-03-31				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/03/2009 4:50:09 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 46483

Part Number: D205596403

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
clamp(per MIL-DTL-8783C)  
batch 109182

AT 09-04-01

14.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pick:  
Qty Part number Description Batch  
2 D2940-1 Support 41870

AT 09-04-01

15.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-103

Magnobond 6398 Batch: 107900

EXP: 09-09-19

AT 09-04-01

★ SEE W/O CHG

3- Install supports and clamps per Dwg D205-596-103. Torque clamps to 80-100 in lb. as per dwg

AT 09-04-02

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1

POSITIVE RECALL

EFFECTIVE 09.03.31 AUTH CP

RELEASED CP DATE 09.04.02

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-103B

Location: Rev E

★ SEE W/O CHG

9/4/02 SP

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/02

Job Completion



MF 09-04-02

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-04-01	15.0	<del>table and new</del> new holes for table setup conform to half span between supports of 15.75" CLAMP TOWERS IN PLACE FOR SETUP. <small>WAIT FOR ENG APPROVAL BEFORE DRILLING IN PLACE.</small>	BT	09-04-02		09.04.01 pe Q81042	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

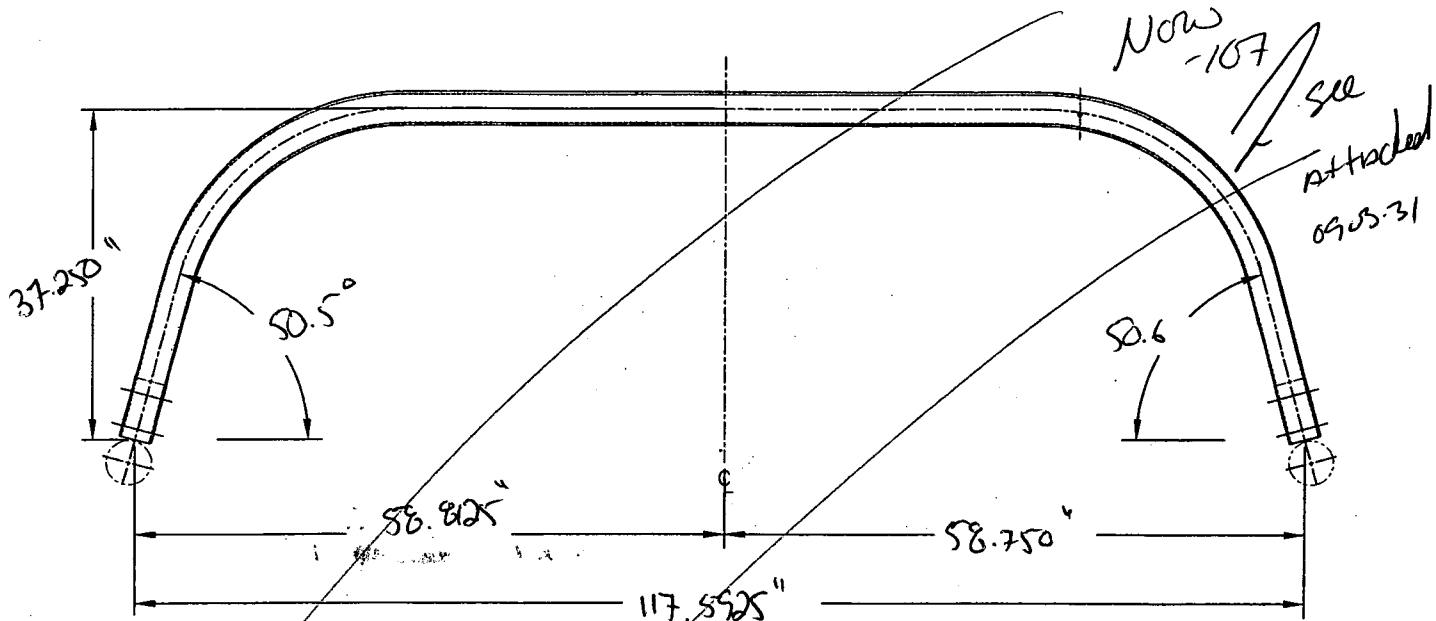
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46483
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8



Comments

QC15 Inspection	S
Date	09/03/07

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	

**PARTS LIST:**

Qty	Part Number	Description
X	D205-596-103	CROSSTUBE ASSEMBLY, HI-HI AFT
1	D6008-180	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

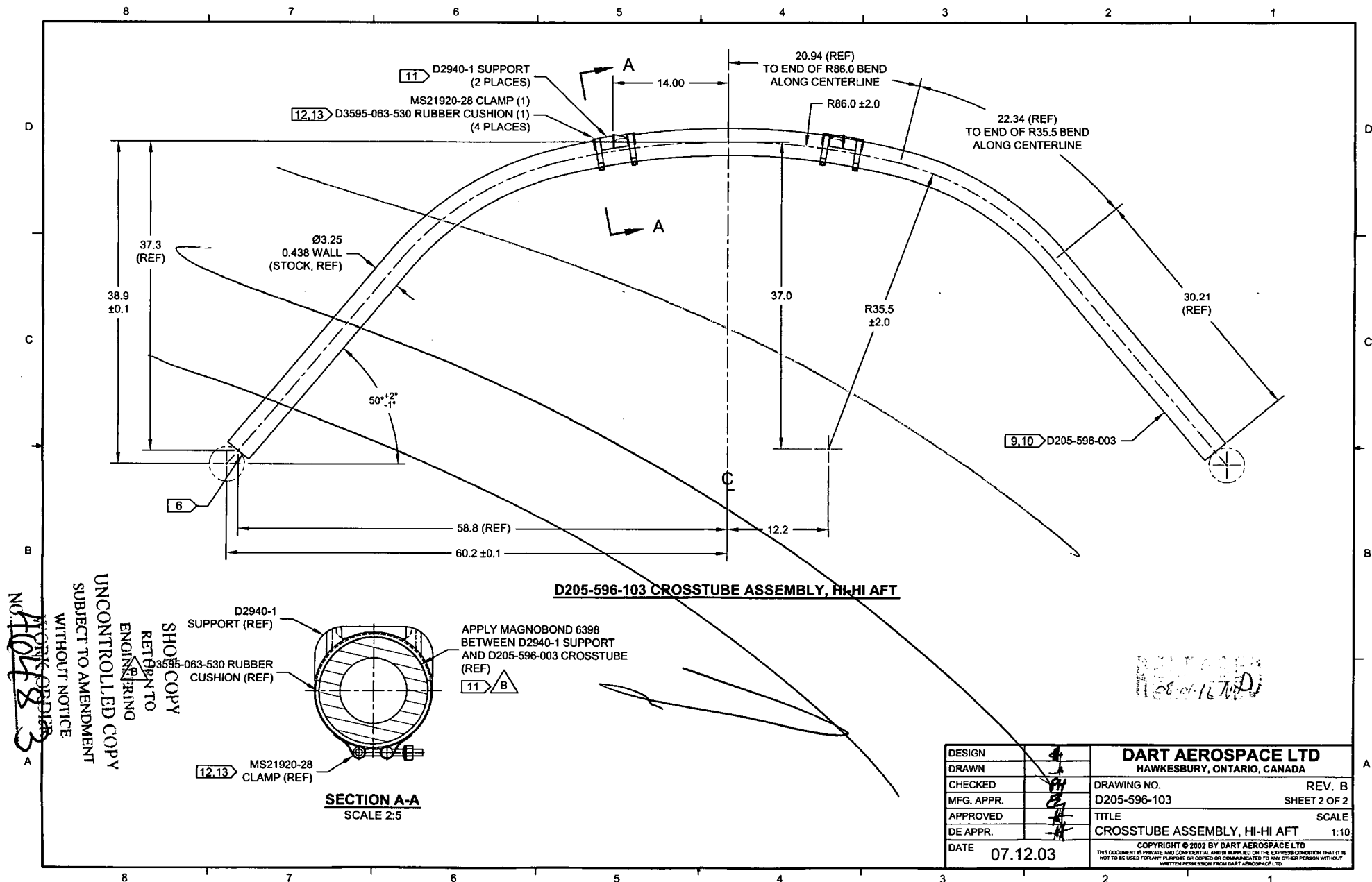
- 1) MATERIAL: MANUFACTURE FROM D6008-180  
FINISHED LENGTH =  $146.98 \pm 0.02$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 55 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE/SUPPORT.  
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER  
MS21920-XX CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF  
1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

08.01.16 MP

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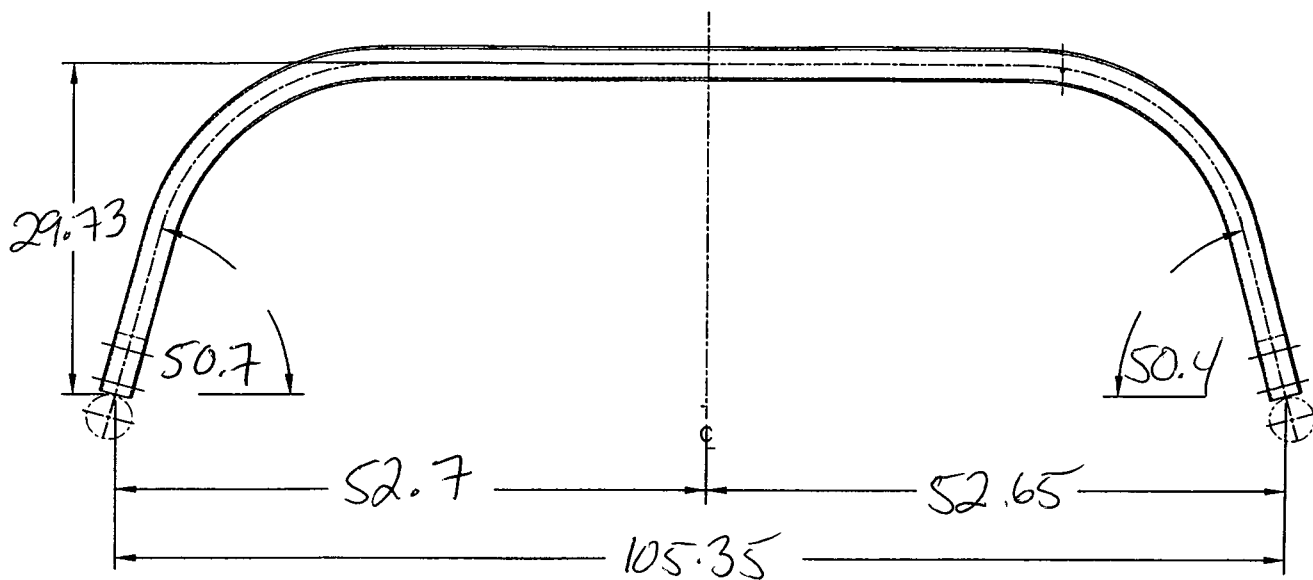
B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D205-596-103	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





DART AEROSPACE LTD		Work Order: 46483
Description: Crosstube High-High Aft		Part Number: D205-596-107
Inspection Dwg: D205-596-107 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	29.7	29.9
1/2 Span	52.4	52.6
Angle	49	52
Total Span	104.8	105.2



Comments

QC15 Inspection	
Date	0903.31

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**PARTS LIST:**

Qty	Part Number	Description
X	D205-596-107	CROSSTUBE ASSEMBLY, HI-HI AFT
1	D6008-180	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6008-180  
FINISHED LENGTH =  $127.28 \pm 0.02$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 50 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.  
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER  
MS21920-XX CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF  
1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

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NO. 464183

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>4</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>4</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>PH</u>	D205-596-107	SHEET 1 OF 2
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

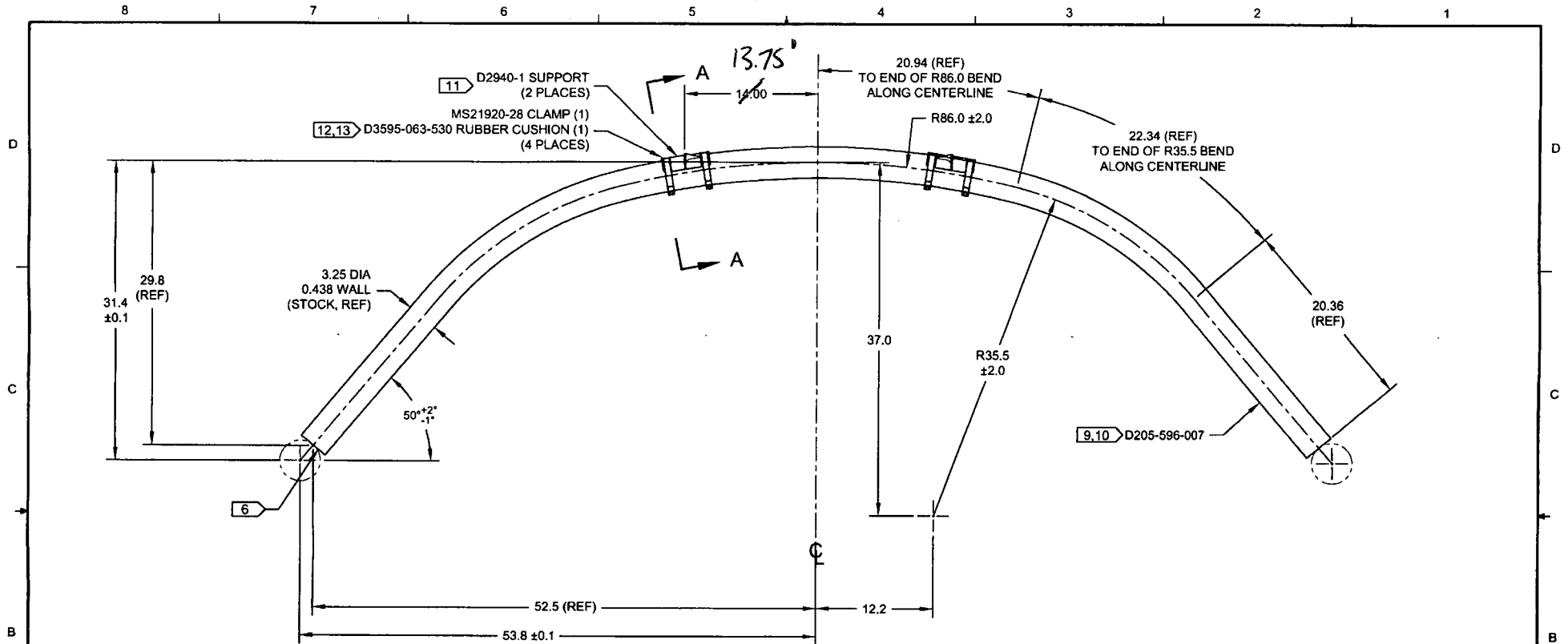
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

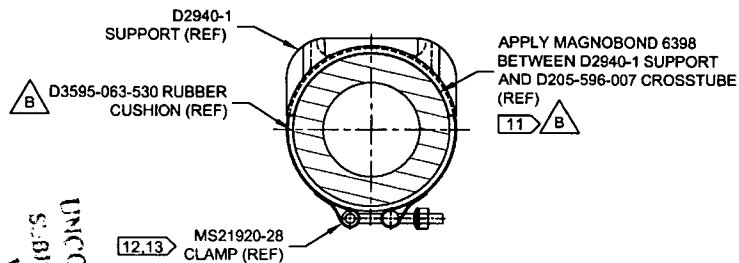
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

04.03.31



**D205-596-107 CROSSTUBE ASSEMBLY, HI-HI AFT**



**SECTION A-A**  
SCALE 2:5

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D205-596-107 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		CROSSTUBE ASSEMBLY, HI-HI AFT 1:10
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 REV. D OR EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 REV. 3 OR EARLIER

REF CANADIAN STC: SH03-6  
REF FAA STC: SR01742NY  
REF EASA STC: EASA.IM.R.S.01198

## PURPOSE:

The required spacing between the supports for installation of crosstubes on 214B/B-1 model aircraft is different than the spacing for 205/212 model aircraft. Additional installations are available from Dart with supports positioned for compatibility with 214 aircraft. The supports on existing Dart D205-596-101/-103/-105/-107 crosstubes must be repositioned before installation on 214 aircraft.

## CHANGE:

The following crosstube installations are available from Dart for the 214B/B-1 model aircraft:

QTY -011B	QTY -013B	Part Number	Description	Equivalent 205/212 Kit
X		D205-594-011B	EXTENDED HEIGHT LANDING GEAR KIT, (39", 214)	D205-594-011
	X	D205-594-013B	EXTENDED HEIGHT LANDING GEAR KIT, (31", 214)	D205-594-013
1		D205-596-101B	CROSSTUBE ASSEMBLY, HI HI FWD (214)	D205-596-101
1		D205-596-103B	CROSSTUBE ASSEMBLY, HI HI AFT (214)	D205-596-103
	1	D205-596-105B	CROSSTUBE ASSEMBLY, HI HI FWD (214)	D205-596-105
	1	D205-596-107B	CROSSTUBE ASSEMBLY, HI HI AFT (214)	D205-596-107

The D205-596-101B/-103B/-105B/-107B are the same as the equivalent crosstubes listed in the table above. However, the spacing of the supports is narrower to accommodate 214 model aircraft, as illustrated in Figure 1 of this service instruction. The new kits are otherwise installed, maintained, and have identical replacement parts lists per their equivalent crosstubes in Installation Instructions IIN-D205-594 and Instructions for Continued Airworthiness ICA-D205-594. All statements in FMS-D214-594 that apply to the D205-594-011/-013 landing gears are also applicable to D205-594-011B/-013B landing gears.

Dart D205-596-101/-103/-105/-107 crosstubes may also be installed on 214B/B-1 model aircraft. To install on 214 aircraft, the supports on the -101/-103/-105/-107 crosstubes must be repositioned per the following procedure:

- 1) Remove the supports per section 32.3 of ICA-D205-594.
- 2) Reinstall the supports per section 32.4 of ICA-D205-594. However, locate the supports with the vertical face 13.75" (349mm) from the crosstube center as shown in Figure 1 of this service instruction.
- 3) The crosstubes should otherwise be installed and maintained per Installation Instructions IIN-D205-594 and Instructions for Continued Airworthiness ICA-D205-594.
- 4) If the modified crosstubes or D205-596-101B/-103B/-105B/-107B crosstubes are to be installed on 205/210/212/UH-1 model aircraft, reinstall the crosstube supports with the vertical face 14.00" (356mm) from the crosstube center, as indicated in ICA-D205-594.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

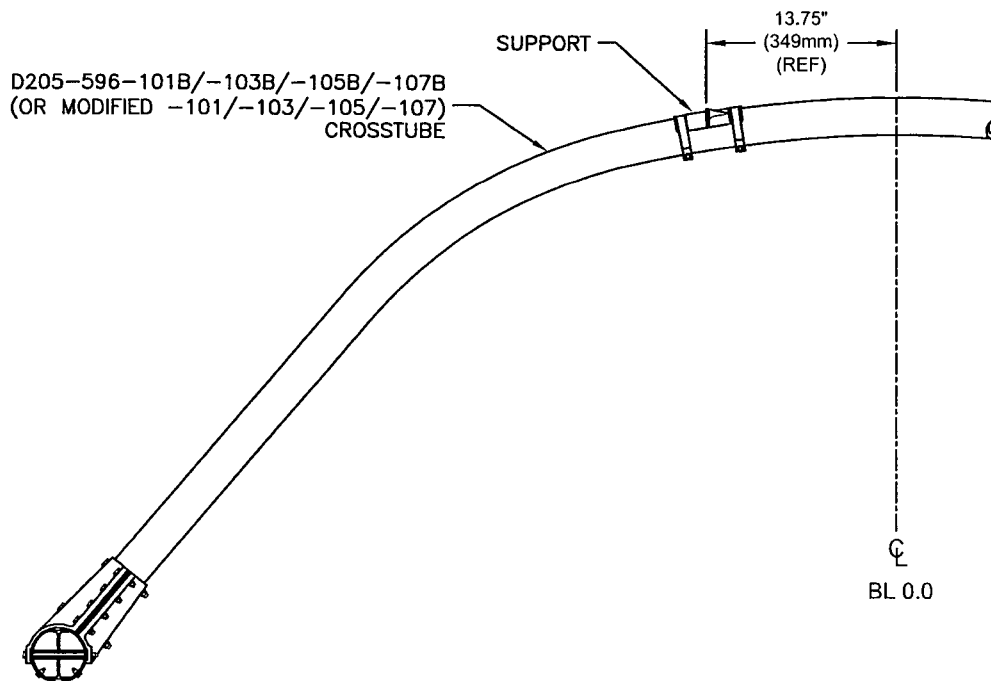
DATE: 09.01.30

CERT. NO.: SH03-6

ISSUE NO.: 3

A	NEW ISSUE	CP	09.01.30
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.	N/A	DSI 9455	SHEET 1 OF 2
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**FIGURE 1 - SUPPORT INSTALLATION**

(214B/B-1 AIRCRAFT ONLY)

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D. SHEPHERD (DE # 02)

DATE: 09.01.30  
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